

Work Order ID 117733

Thursday, May 01, 2014 10:18:51 AM

117733

Page 1

Item ID: D3140-05

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Door

Start Date: 5/1/2014 Start Qty: 1.00

1

Cust Item ID:

Required Date: 8/22/2014 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: CLDate: 14/05/01

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3140

Rev F

100

0.00

100

Packaging

Memo

0.00

Packaging

Pick kit to ship to Delastek

CL 14/07/24

110

QC4- 100% Inspect kits for completeness

0.00

110

QC

Memo

0.00

Quality Control

S 15/01/134DAS
3/2
2/3

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 117733

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Page 2

Item ID: D3140-05

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Door

Start Date: 5/1/2014 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 8/22/2014 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120

0.00

120

Purchasing

Memo

0.00

Purchasing

Issue P/O: 24037

Purchase Part Number: D3140-05

Supplier: Delastek

Ship kit and make as per dwg

Conformity Certificate and Process sheet required

CL 14/07/24

130

Receive & Inspect for Damage & Mat'l Certs

0.00

130

Packaging

Memo

0.00

Packaging

IX SP14-12-18

140

QC6- Inspect dimensions to drawing

0.00

140

QC

Memo

0.00

Quality Control

Ensure a copy of certification of conformity and process sheet from Delastek is attached.

DAS
38
9-891 15-01-13

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
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Handling/Pre									
Material									
Operator									
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Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

Work Order ID 117733

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117733

Page 3

Item ID: D3140-05

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Door

Start Date: 5/1/2014 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 8/22/2014 Req'd Qty: 1.00 ***1***

Customer:

Reference:

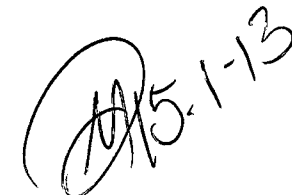
Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <u>CA2</u>	0.00						15-01-13	
150									
Packaging	Memo	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									



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Handling/Pre									
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Operator									
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Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other _____ _____ _____
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Picklist Print

Thursday, May 01, 2014 10:18:50 AM

Page 1

Work Order ID: 117733

117733

Parent Item: D3140-05

D3140-05

Parent Item Name: Door

Start Date: 5/1/2014

Required Date: 8/22/2014

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 12.01.17 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3140-87		Manufactured	No			100	Each	8.0000	1	1			
D3140-87													
Doubler													

Location Loc Qty Loc Code

ST205	6	
78719	6	
ST241A	2	
90778	2	

D3140-95		Manufactured	No			100	Each	13.0000	3	3			
D3140-95													
Doubler													

Location Loc Qty Loc Code

ST027	13	
52265	1	
78722	12	

D3140-97		Manufactured	No			100	Each	3.0000	1	1			
D3140-97													
Doubler													

Location Loc Qty Loc Code

CA	1	
37773	1	
ST028	2	
78728	2	

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Doc/Data ☐									
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Handling/Pre ☐									
Material ☐									
Operator ☐									
Offset/Setup ☐									
Process ☐									
Supplier ☐									
Training ☐									
Transport ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Page 2

Thursday, May 01, 2014 10:18:51 AM

Work Order ID: 117733

117733

Parent Item: D3140-05

D3140-05

Parent Item Name: Door

Start Date: 5/1/2014

Required Date: 8/22/2014

Start Qty: 1.00

Required Qty: 1.00

D3140-241

Manufactured No

100

Each

3.0000

1

1

D3140-241

Doubler

C214109/05

Location

Loc Qty

Loc Code

CA

3

78723

3

D3140-301

Manufactured No

100

Each

8.0000

1

1

D3140-301

Doubler

C214105/05

Location

Loc Qty

Loc Code

CA

8

78717

8

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



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DART
AEROSPACE

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO24037

Purchase Order Date 5/1/2014
PO Print Date 9/10/2014

Page Number 4 of 6

Order From:

VU-DEL003

Ship To: DART AEROSPACE LTD

DELASTEK INC
699 SE AVENUE, LOCAL C.P 10100
GRAND-MERE, QC G9T 5K7
CANADA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 819 533 5788

Ship To Contact

Ship To Phone

Ship Via:

FedEx PI collect

Ship Acct:

Buyer

Michael Gregoire

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

USD

FOB

EXW - (Ex Works)

D3140-05P

Door

9/10/2014

No

9/10/2014

1.00 ✓
Each

\$8,842.92

Manufacture as per Drawing D3140 rev.F

8/14/12-18

Line Total:

D3140-06P

Door

9/10/2014

Yes

9/10/2014

1.00 ✓
Each

\$8,842.92

Manufacture as per Drawing D3140 rev.F

Line Total:

D3140-07P

Door

9/10/2014

Yes

9/10/2014

1.00 ✓
Each

\$8,842.92

Manufacture as per Drawing D3140 rev.F

Line Total:

PO Instructions: Fedex Acc# 151793240

Note:

9/10/2014



DELASTEK Inc.
2699 5e Avenue
Local 14,
Grand-Mère, Québec G9T 2P7
Canada
Tel.: (819) 533-5788
Fax: (819) 533-3494

PACKING SLIP

CERTIFICATE OF COMPLIANCE

Invoice No.	59025
Customer No.	DART US

Bill To

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Telephone : 613-632-5200

Contact : Linda Lacelle

Ship To

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Telephone : 613-632-5200

Contact : Linda Lacelle

Ship Date	Order Date	Our SO #	Ordered by	Your PO#	Terms
16-12-2014	01-05-2014	24599	Michael Gregoire	PO24037 REV 1	Net 30 days USA
Ship Via	F.O.B.	Salesperson	GST/PST		
Fedex Freight LTL Collect	Point de départ	Melody Shapcott, ext. 235			
Order Qty	B.O Qty	Current Ship	Item number	Description	
1	0	1	DKC135-0017	Line #9 D3140-05 Door Left Non Assy (Grosse) U of M: Chaq DWG D3140 REV. F Serial # 64183 Lot # 64183	
1	0	1	DKC135-0019	Line #10 D3140-06 Door Right Non Assy U of M: Chaq (Grosse) DWG D3140 REV. F Serial # 64184 Lot # 64184	
1	0	1	DKC135-0018	Line #11 D3140-07 Door Left Non Assy (Petite) U of M: Chaq DWG D3140 REV. F Serial # 64183 Lot # 64183	
1	0	1	DKC135-0020	Line #12 D3140-08 Door Right Non Assy (Petite U of M: Chaq) DWG D3140 REV. F Serial # 64184 Lot # 64184	

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

Accepted by:

Mathieu Ayala
Quality department



AQ-357

☐ Cust. ☐ Adm. ☐ Quality ☐ Ship.